

Date: Thursday, 10/11/2007 2:55:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 35139	
Estimate Number : 11396	
P.O. Number : <i>N/A</i>	Part Number : D32993
This Issue : 10/11/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3299 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 29560	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/30/2007
Checked & Approved By : <i>[Signature]</i> 07.10.11	Qty: <i>15</i> Um: <i>10</i> Each
Comment : Est: A 04.10.04 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6H1000	6061-T6 1" HexBar
-----	--------------	-------------------



Comment: Qty.: 0.1925 f(s)/Unit Total : 1.9247 f(s)

6061-T6 1" HexBar

Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.00" Hex

(M6061T6H1.000)

Identify as D3299-3

Batch *M102605*

M100720 0'2'

07-12-11 RD 07/12/12

2.0	HAAS	HAAS CNC VERTICAL MACHINING #1
-----	------	--------------------------------



Comment: Machine as per Folio FA452 and Dwg D3299

Deburr

RD 07/12/12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RD 07/12/12

(15)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

IL 07/12/12

5.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
-----	-----------------	-----------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: *5290*

Anodize as per Dwg D3299

Possible Supplier: TNM Paint

Material release note is required

(X15) AS
07/12/14 15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 10 Date: 08/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:55:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 35139

Part Number: D32993

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

20 8/01/04 (5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/07 (15)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 82

AS 08/01/07 (15)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20 08/01/08 (15)

Job Completion



mi 2008/1/8
U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35139
Description: Fitting		Part Number:	D3299-3
Inspection Dwg: D3299	Rev: B4	Page 1 of 1	





FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

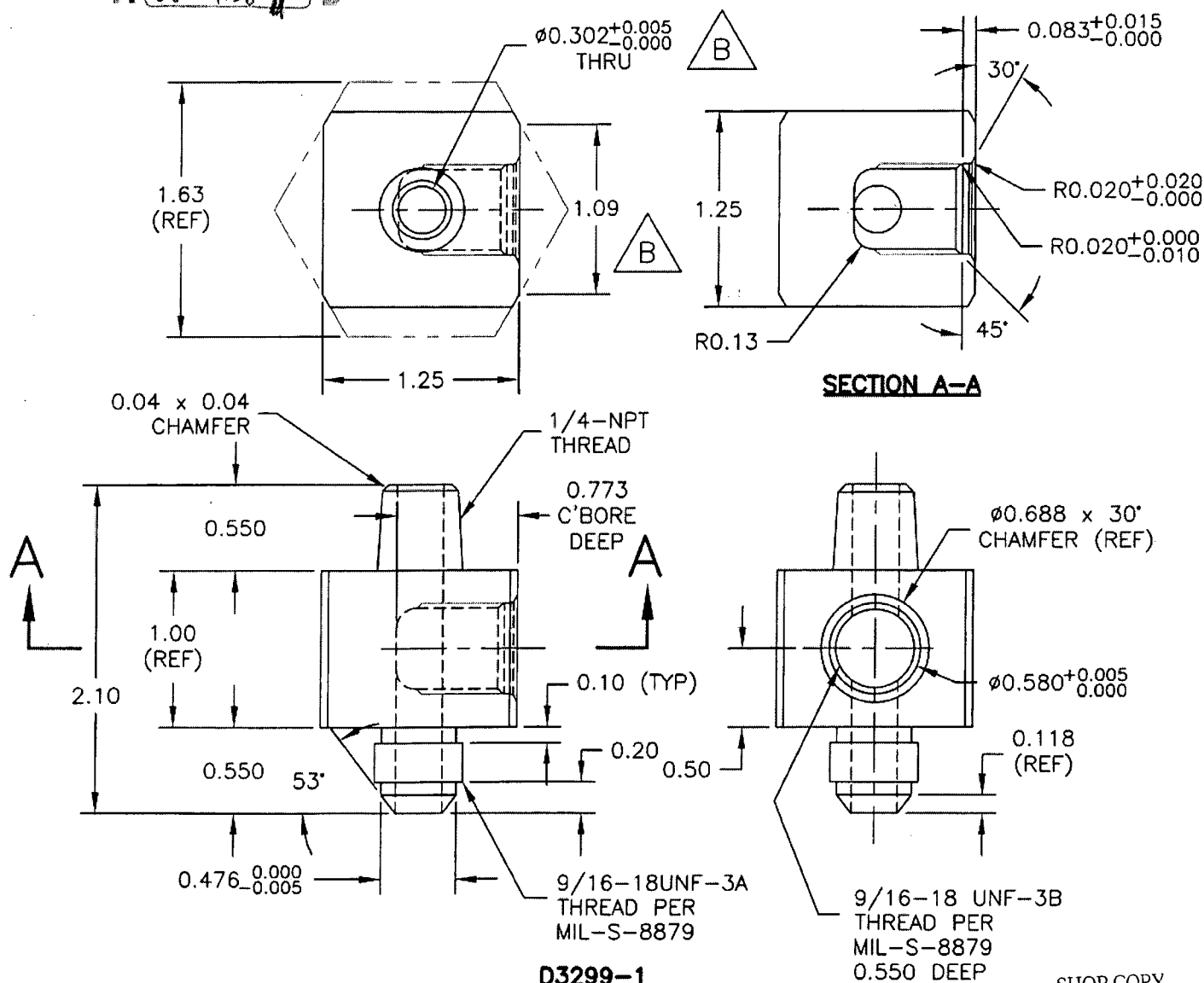
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.005				
Ø0.302	+0.005/-0.000	.307				
0.550	+/-0.010	.547				
0.63	+/-0.030	.631				
2.08	+/-0.030	2.083				
0.900		.900				
53°		53°				
0.476	-0.005/+0.000	.472				
MOW for 9/16"-18	Min = 0.5653 Max = 0.573	.573				
0.200	+/-0.030	.190				
0.450	+/-0.010	.440				
0.10	+/-0.030	.120				
Length of Engagement for 1/4 NPT 0.227	+/-0.010	.217				

Measured by: RD	Audited by: J.L	Prototype Approval:	N/A
Date: 07/12/12	Date: 07/12/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.17	New Issue	KJ/JLM	
B	05.05.25	-0.005/+0.000 added to 0.476	KJ/JLM	

DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3299 REV. B SHEET 1 OF 3	
DATE 05.04.28		TITLE FITTING		SCALE 1:1	
A	04.07.06	NEW ISSUE			
B	05.04.28	1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$			

RELEASED
05-04-28



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (MIL-STD-883C)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR III
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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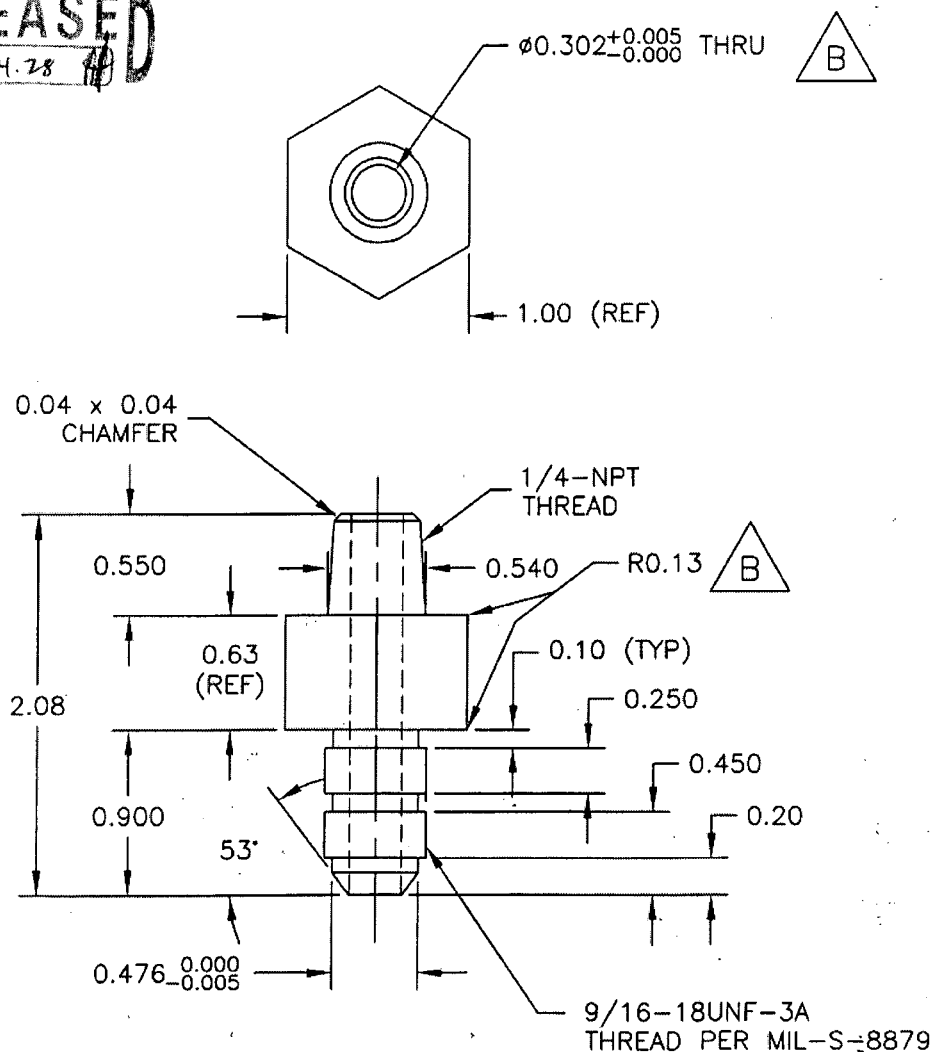
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DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED
05.04.28 #



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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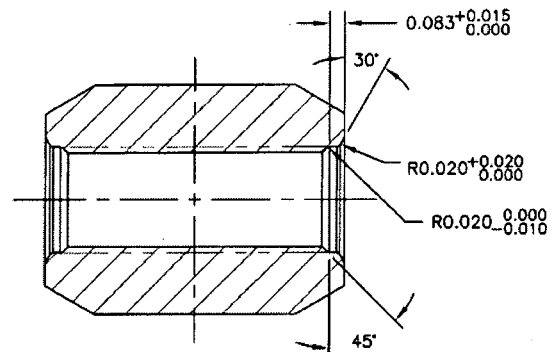
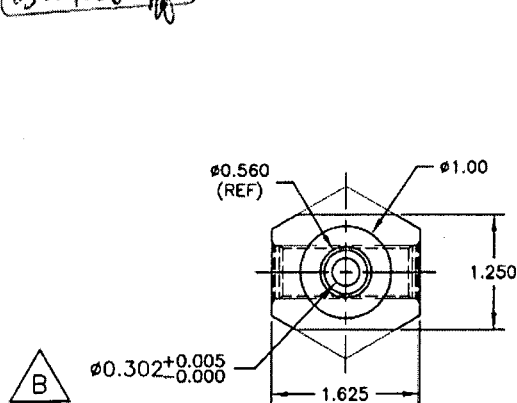
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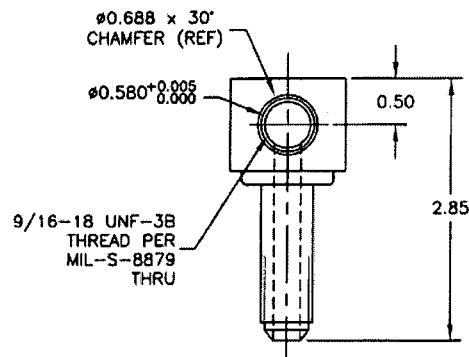
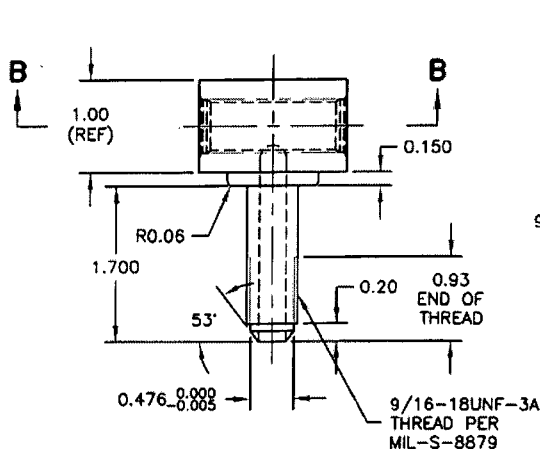


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CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED
05.04.28



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

61066

21-Dec-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITEPURCHASE ORDER/
NO. DE COMMANDE:

00005290

5292



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	50	50	D103858B	B34944	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	60	60	D103859B	B34968	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	15	15	D32993	B35139	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
4	13	13	D32991	B35138	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

